



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-011
Job Sheet 198535



Part No: D350-636-011

Job Qty: 1 pcs

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D2750-041 REV.H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP
Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22
revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-
594 DD VERF:JLM IPP REV:S 18.11.09 AS PER ECN18-830 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
10	Skidtubes - 1	1 pcs		8/30/19	0.00	4.55	Skidtubes - 1			DD
							Skidtubes - 2			
							Skidtubes - 3			
							Skidtubes - 4			
							Skidtubes - 5			SE
							Skidtubes - 6			
							Skidtubes - 7			
20	QC 10	1 pcs		8/30/19	0.00	0.00	QC 10 - 10			B
							QC 10 - 18			
							QC 10 - 24			
							QC 10 - 43			
							QC 10 - 50			
							QC 10 - 58			
							QC 10 - 9			
30	QC 5	1 pcs		8/30/19	0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			

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S203581 LH

140 Handfinish - 1-1 Chemical-B4B	1 pcs	8/30/19	0.00 0.93	QC 5 - 50	02
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 10 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	8/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	8/5
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	

					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	8/30/19	0.00 4.55	Skidtubes - 1 - B4B		DD
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		BF
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
170 QC 10	1 pcs	8/30/19	0.00 0.00	QC 10 - 10		
				QC 10 - 18		
				QC 10 - 24		
				QC 10 - 43		
				QC 10 - 50		α
				QC 10 - 58		
				QC 10 - 9		
180 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		ε
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
190 Handfinish - 2-1 Pressure-B4B	1 pcs	8/30/19	0.00 0.33	Handfinish - 2 - 1 - B4B		SEP 25 2019
				Handfinish - 2 - 2 - B4B		
				Handfinish - 2 - 3 - B4B		
				Handfinish - 2 - 4 - B4B		
200 Spray Paint - 2 - B4B	1 pcs	8/30/19	0.00 0.91	Spray Paint - 1 - B4B		AL 19.9-26
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
204 QC 14	1 pcs	8/30/19	0.00 0.00	QC 14 - 15		14-10-01
				QC 14 - 2		
				QC 14 - 34		
				QC 14 - 41		
				QC 14 - 51		
				QC 14 - 58		
				QC 14 - 59		
				QC 14 - 9		
				QC 14 - 68		

230 Handfinish - 4-1-Assembly-B4B	1 pcs	8/30/19	0.00 0.93	QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
				Handfinish - 4 - 1 - B4B	<i>el 14-14</i>
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
240 QC 5	1 pcs	8/30/19	0.00 0.00	Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	8/30/19	0.00 0.00	QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	

DAS
OCT 02 2019 40
9-89

				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	PC
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1	8/30/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
270 Packaging 3-1 - Stock - B4B	1	8/30/19	0.00 0.00	QC 4 - 75	
				Packaging 3 - 1 - B4B	DAS
				Packaging 3 - 2 - B4B	78
				Packaging 3 - 3 - B4B	9-89
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1	8/30/19	0.00 0.00	DC - 1 - B4B	DAS 21 OCT 04 2019
	pcs			DC - 2 - B4B	8-39
280 QC 21 - FG	1	8/30/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	DAS 21 OCT 04 2019
				QC 21 - SA - 53	

Part Op 110 - (Skidtubes) 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT
 Descriptions: end per dwg D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6-Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011 8-Grind welds flush as per Dwg D2750

120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)

160 - (Skidtubes) 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5200623 exp. date: 07/25/2020 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139011 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending to paint.

170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125

204 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

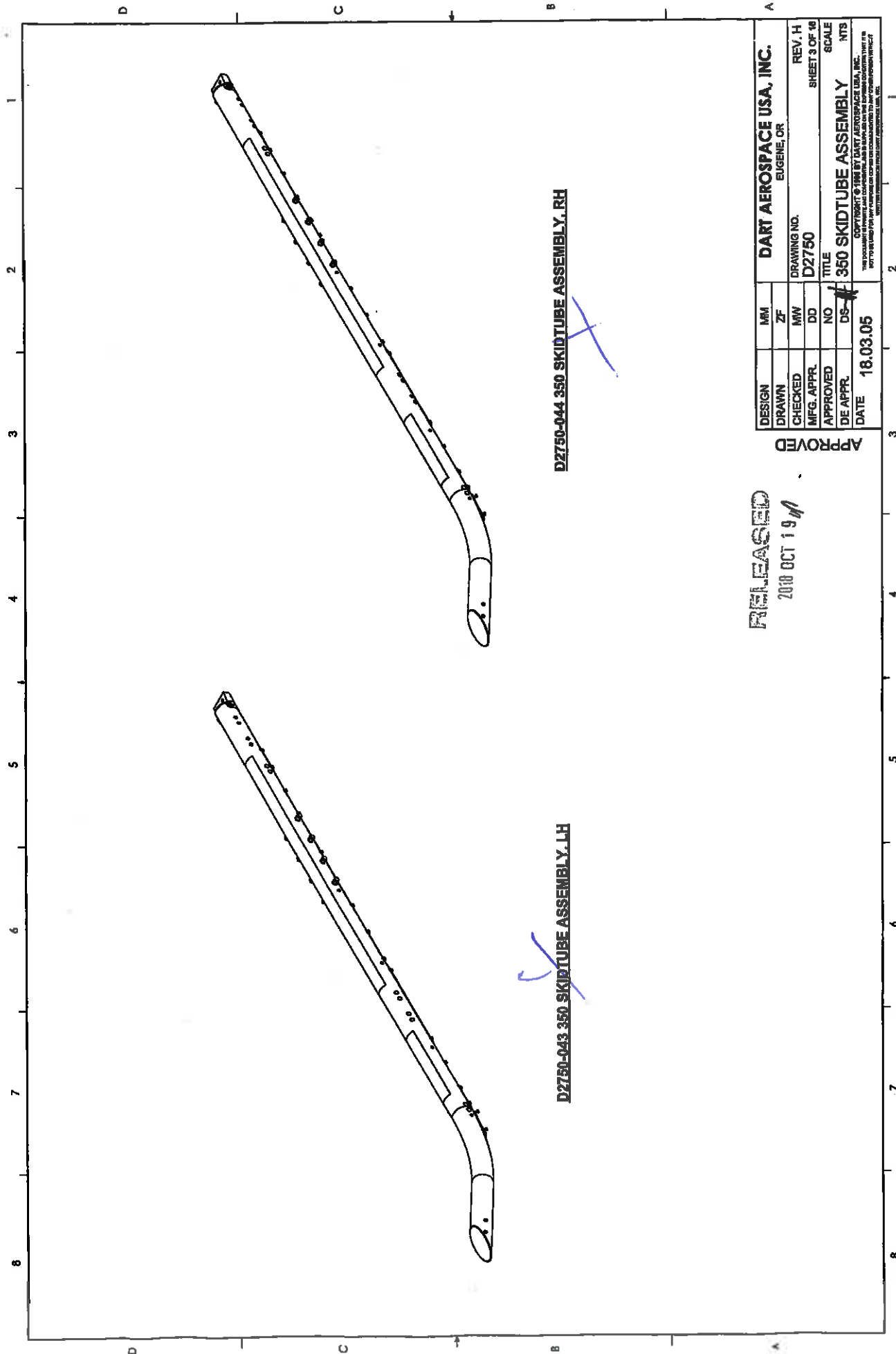
230 - (Assemble as per dwg) 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: 5200623 EXP DATE: 20-7-27 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 20-7-25 5- Coat all exposed fasteners with "LPS Procyon" batch: M133690

240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****
 270 - (Identify as per dwg & Stock Location: _____) Package as per PPP D350-636-011 Location : FG108
 275 - (Document Control) record fwd angle: 89.5 Photocopy blue file and type labels per PPP D350-636-011 CHG 008
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM				012189
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skiddtubes - 1	5197557
D2744	Cap	1 pcs (1 ea)	110-Skiddtubes - 1	5192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skiddtubes - 2 - B4B	52041740
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skiddtubes - 2 - B4B	5194932
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skiddtubes - 2 - B4B	5210529
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skiddtubes - 2 - B4B	5191622
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5203283
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167182
AN6C44A	Bolt 5160243(1)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5216233(63)
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5217487
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5206309
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5184950
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5204549
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5205337
D3537-1	Wearpad 5204500(2)	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	52077390
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184197
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5211472
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5208241
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5210540
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5216287-1
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5197252
NAS1149C0332R	Washer (AN960C10L)	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	50760173
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5214921
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5057658
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	519943
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	519215
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5201916
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184404
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5197863
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5199486
D3532-1	Spacer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5217898
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5215506
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5116718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	7	0
	D2744	1	44	0
160-Skidtubes - 2 - B4B	D2739	1	7	0
	D2743	8	208	0
	D3490-1	4	133	0
	D3490-3	4	66	0
	ALS4-1032-225	38	827	0
230-Handfinish - 4-1-Assembly-B4B	AN3C5A	34	765	0
	AN3C6A	4	141	0
	AN6C44A	4	114	0
	AN8C35A	1	28	0
	D2745	8	48	0
	D3488-3	1	11	0
	D3492-1	8	51	0
	D3492-3	8	7	0
	D3537-1	3	51	0
	D3631-1	8	360	0
	D3791-1	1	3	0
	D3793-1	1	6	0
	D3793-3	1	0	0
	D3793-5	1	3	0
	MS21043-6	4	91	0
	MS21083C8	1	85	0
	NAS1149C0332R	38	3,724	0
	NAS1149C0832R	1	292	0
	NAS1515H3L	4	173	0
	NAS1611-010	8	203	0
	NAS1611-013	8	200	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	117	0
	D2741	1	52	0
	D3493-1	2	53	0
	D3532-1	2	39	0
	MS21083C8	2	85	0
	NAS1149D0863J	2	371	0
Part Specifications				
Specifications could not be found.				

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D2750-044 350 SKIDTUBE ASSEMBLY, RH

D2750-043 350 SKIDTUBE ASSEMBLY, LH

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2010 OCT 19

APPROVED

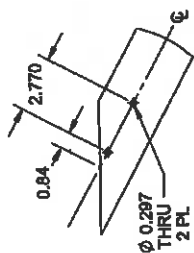
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MM	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 3 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS-1	350 SKIDTUBE ASSEMBLY NTS	
DATE	18.03.05	COPYRIGHT © 1985 BY DART AEROSPACE USA, INC.	

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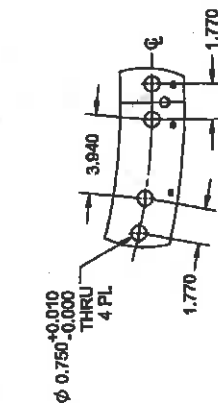


**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**

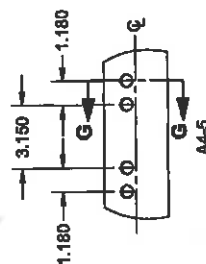
D2750-1 LH SKIDTUBE



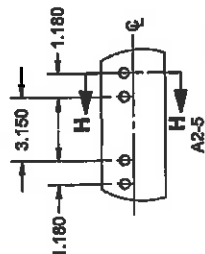
D7-5
DETAIL A
SCALE 2X



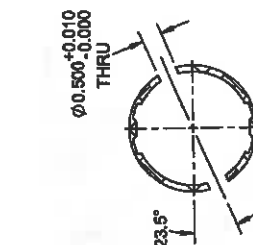
C7-5
DETAIL B
SCALE 2X



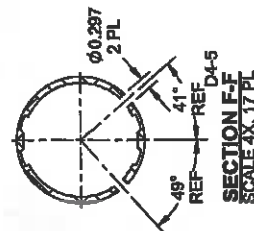
D5-5
DETAIL C
SCALE 2X



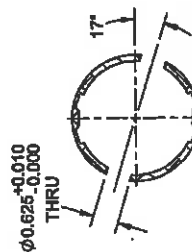
D3-5
DETAIL D
SCALE 2X



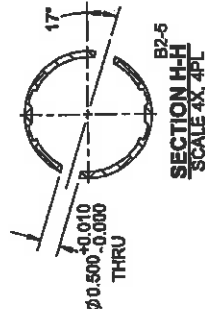
D5-5
SECTION E-E
SCALE 4X, 2 PL



SECTION F-F
SCALE 4X, 17 PL



B4-5
SECTION G-G
SCALE 4X, 4 PL



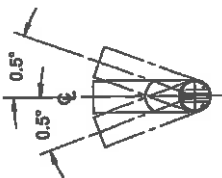
B2-5
SECTION H-H
SCALE 4X 4PL

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DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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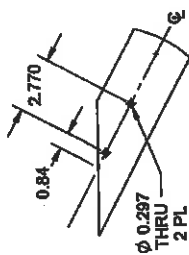
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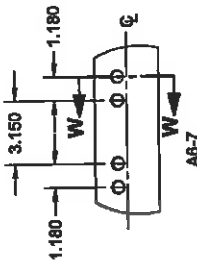


**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**

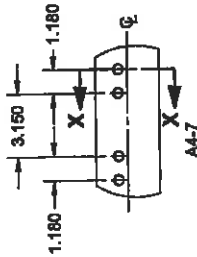
D2750-3 LH SKIDTUBE



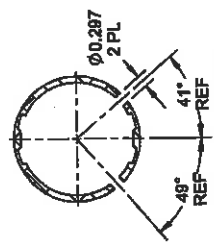
D7-7
DETAILS
SCALE 2X



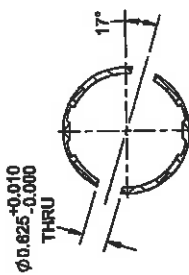
C5-7
DETAIL 1
SCALE 2X



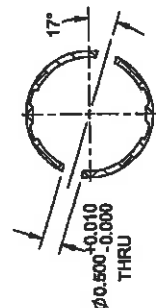
D3-7
DETAIL U
SCALE 2X



D4-7
SECTION V-V
SCALE 4X, 17 PL



B6-7
SECTION W-W
SCALE 4X, 4 PL



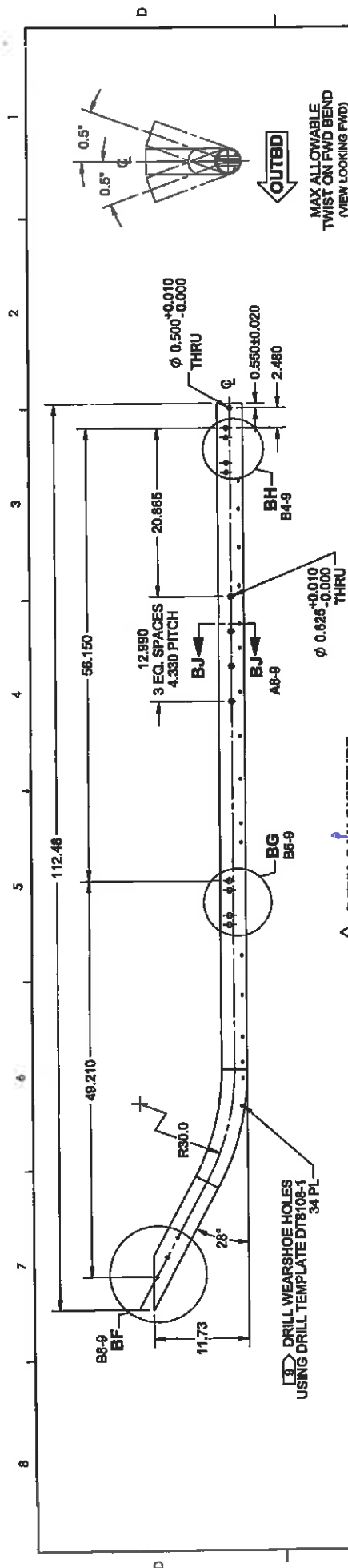
B4-7
SECTION X-X
SCALE 4X, 4 PL

2009 OCT 19 07
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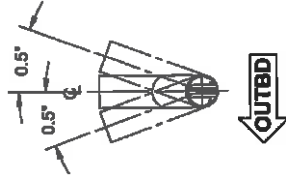
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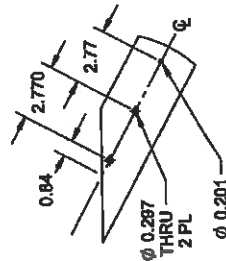
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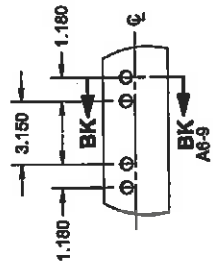
A D2750-5 LH SKIDTUBE



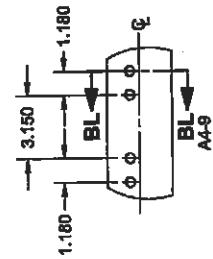
MAX ALLOWABLE
 TWIST ON FWD BEND
 (VIEW LOOKING FWD)



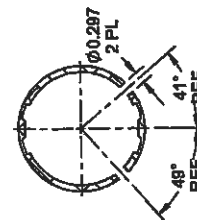
D7-9
DETAIL BF
 SCALE 2X



D5-9
DETAIL BG
 SCALE 2X



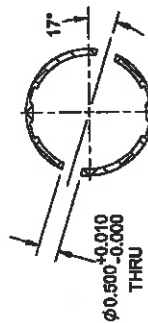
D3-9
DETAIL BH
 SCALE 2X



D4-9
SECTION BJ-BJ
 SCALE 4X, 17 PL



B9-9
SECTION BK-BK
 SCALE 4X, 4 PL



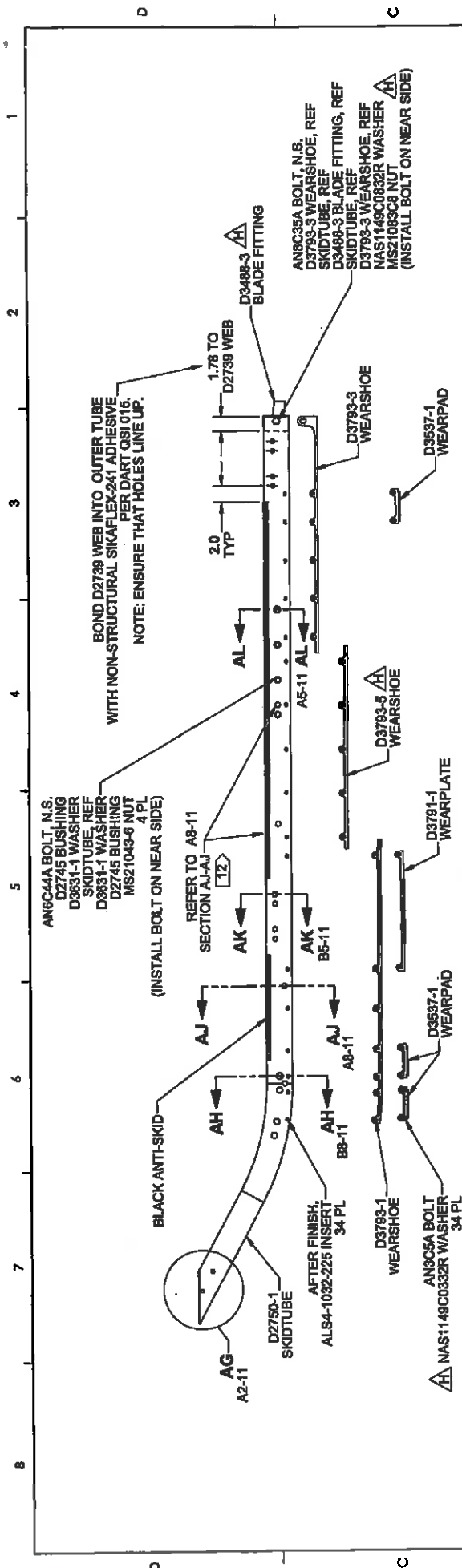
B4-9
SECTION BL-BL
 SCALE 4X, 4 PL

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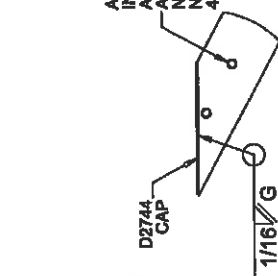
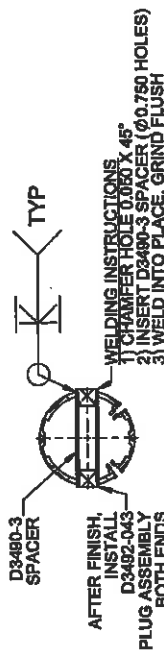
2019 OCT 19

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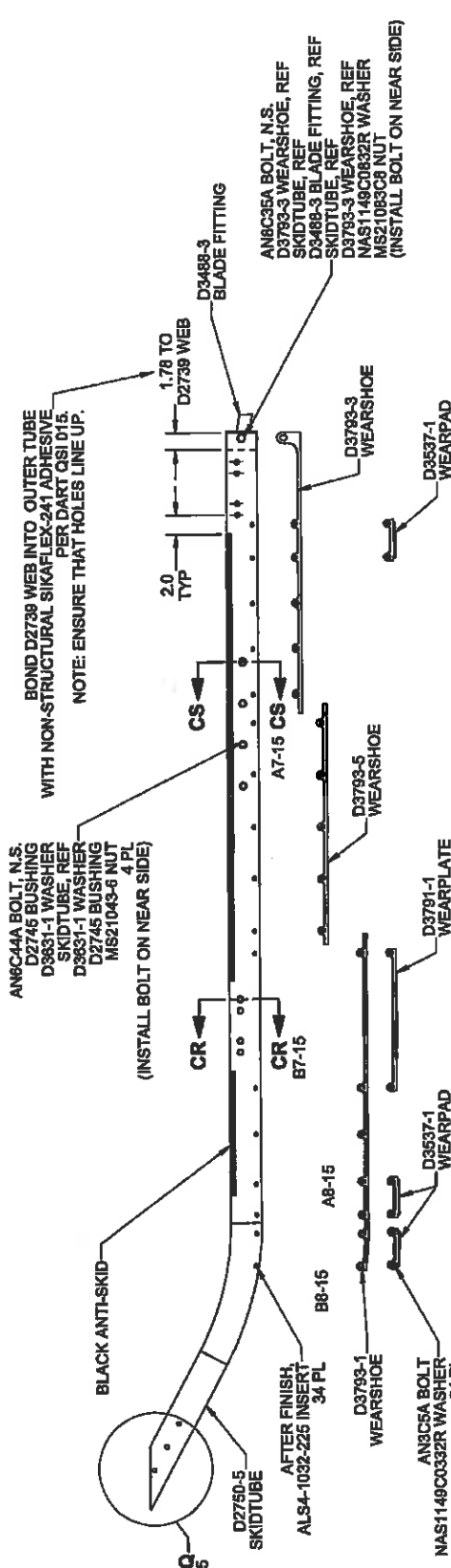
APPROVED



D2750-041 350 SKIDTUBE ASSEMBLY, LH



1 2 3 4 5 6 7 8



D2750-051 350 SKIDTUBE ASSEMBLY, LH

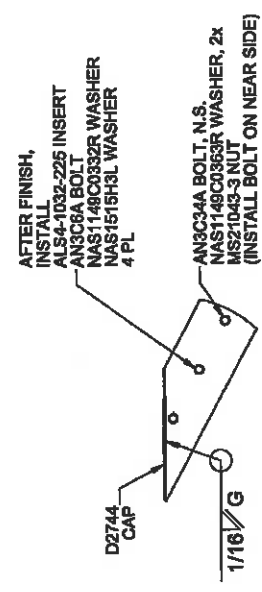


SECTION CR-CR SCALE 3X, 4 PL



SECTION CS-CS SCALE 3X, 4 PL

(HARDWARE REMOVED FOR CLARITY)



DETAIL CQ SCALE 2X

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2018 OCT 19 12

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SCALE							NTS
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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality				DEPARTMENT/PROCESS				MRB (QSI042)			
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition							
Description Work Order Deviation						Completed By							
_____						Lead hand / Supervisor							
_____						QC / QA Coordinator							

Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY									
☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread									
Other/Details:		_____									

Change Record

PAGE 1 OF 1

Part Number: D350-636-011/-011GB/-012/-012GB

Description: SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

[illegible]

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAISER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAISER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149D0863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

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Revision: K

Date: 18.04.04

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE
*23A	1	1	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*24A	1	1	1	1	1	1	1	D3793-5	WEARSHOE (REPLACES D3535-25)
*25A	1	1	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*26A	34	34	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	34	34	NAS1149C0332R	WASHER
*28	34	34	34	34	34	34	34	ALS4-1032-225	INSERT
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
50	2	2						D3532-1	SPACER
****97					1	1		AN3C34A	BOLT
****98					2	2		NAS1149C0363R	WASHER
****99					1	1		MS21043-3	NUT
100A							4	AN526C1032R10	SCREW
100B							4	AN526C1032R18	SCREW

* PART OF D2750-041/-042, D2750-043/-044 OR D2750-051/-052 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

**** PART OF D2750-051 OR D2750-052 ASSEMBLY